

Work Order ID 65142

Thursday, January 06, 2011 3:29:30 PM



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Item ID:	D3213-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Panel				Stop	
Start Date:	1/6/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	1/14/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>1-07-7</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3213	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3213	<input type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-					
2024 .063	Deburr if necessary								

B11-1-10

(8)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-1-10

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

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(X2)

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Item ID: D3213-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur								
140 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							
150 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

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Item ID: D3213-1

Accept

Revision ID:

Item Name: Door Panel

Start Date: 1/6/2011 Start Qty: 8.00

Required Date: 1/14/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 232B</u>	0.00							
	Memo	0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

11/01/12
ME
11-01-11

Picklist Print

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Work Order ID: 65142



Parent Item: D3213-1



Parent Item Name: Door Panel



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 05-11-17 New Issue JLM
 IPP Rev:B 07-02-13 Now on Waterjet JLM
 IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	70.5000	0.4714	3.969684			
										B 11-1-10			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT22	70.5						
						114351	70.5		114351				

8

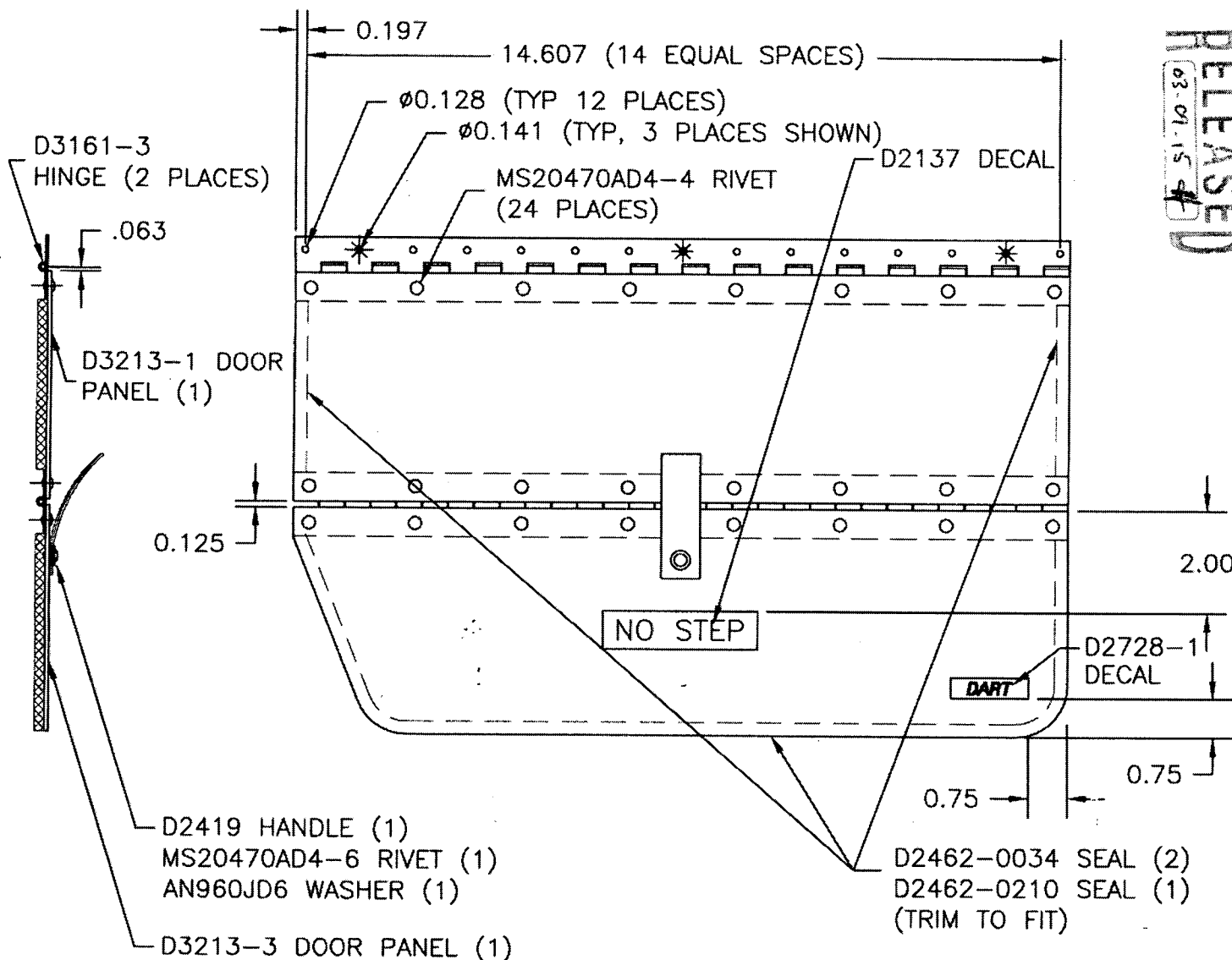
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03-01-15

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO
WITHOUT
WORK
NO

DART

COPIES
11-01-7

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.09.03	03.09.03	D3213
DATE	TITLE	REV. A
03.09.03	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

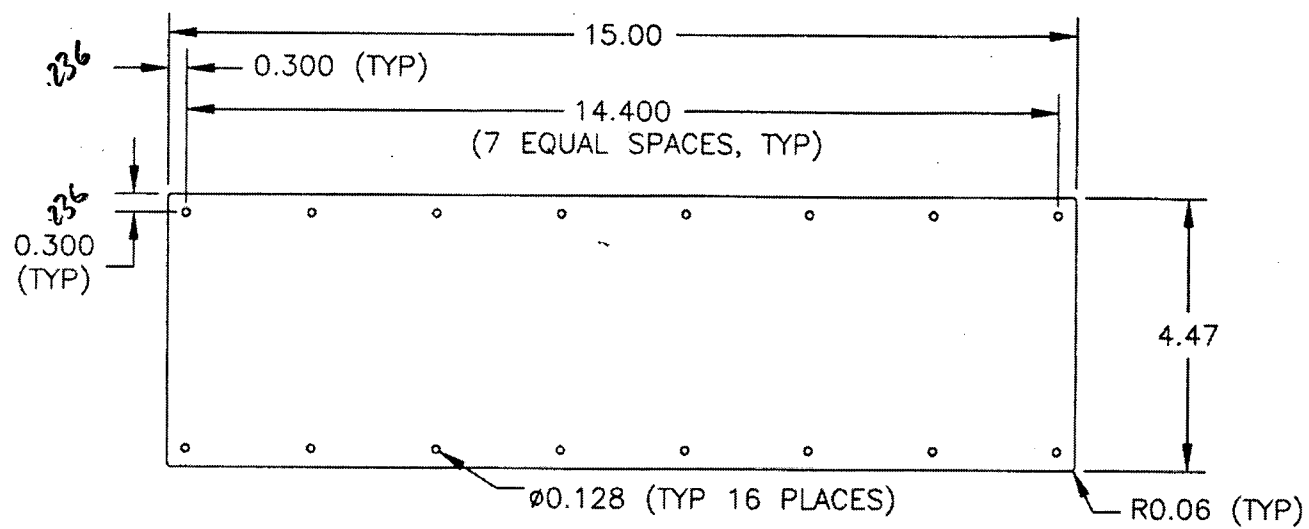
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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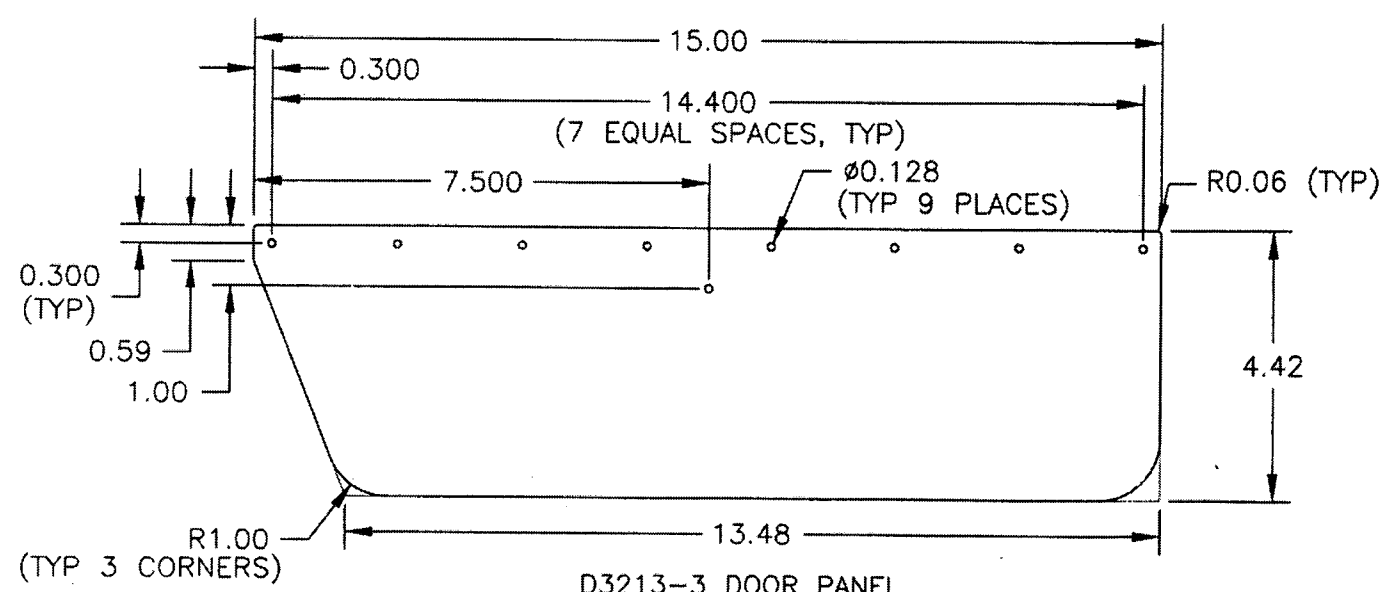
w/o 65142



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries